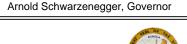
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

### WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-004773 Address: 333 Burma Road **Date Inspected:** 16-Nov-2008

City: Oakland, CA 94607

**OSM Arrival Time:** 1330 **Project Name:** SAS Superstructure **OSM Departure Time:** 2230 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No NA **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG** Fabrication

### **Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

OBG Bay #7

This QA Inspector performed random final visual and ultrasonic (UT) inspections of Floor Beam welds FB016-022-045, FB019-020-043, FB015-024-045, FB010-011-045

FB015-023-045, FB011-017-045, FB009-017-043. The QA Inspector observed the welds that were ultrasonically inspected by this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

Heavy Bay #1

The QA Inspector performed random AWS D1.5 visual and ultrasonic inspections of tower Skin A welds SSD1-SA164E/F-9A/B, SSD1-SA164D/F-31A/B, SSD1-SA164D/F-9A/B and SSD1-SA164D/F-16A/B as listed on the ZPMC Notification of Witness Inspection document #1425 and the welds appear to comply with project specifications. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

ZPMC ultrasonic Inspection personnel have rejected welds SSD1-SA164D/F-16, SSD1-SA164D/F-4,

# WELDING INSPECTION REPORT

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SSD1-SA164D/F-25, SSD1-SA164D/F-28, SSD1-SA164E/F-20, SSD1-SA164E/F-25, SSD1-SA164E/F-31 and SSD1-SA164E/F-1. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

## **Summary of Conversations:**

See above.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer